

Work Order ID 69874

Tuesday, May 24, 2011 8:25:39 AM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 5/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
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Number

Insp.
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IIN-D350-636	H

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Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

8/6/20

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W/O		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69874

Tuesday, May 24, 2011 8:25:40 AM



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Item ID: D350-636-011

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Revision ID:

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Item Name: Skidtube LH

Start Date: 5/24/2011 Start Qty: 1.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB

11/06/02

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

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Qty

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Number

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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004

A/R Aluminum Rod batch: ml174156

BE 11/06/03
BB 11/06/03

12-Grind welds flush as per Dwg D2750

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Sub 6663

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Sub 6663

Memo

0.00



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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
	HandFinish	0.00							
	Memo								
	Hand Finishing								
150	QC3- Inspect Part Finish	0.00							
	QC	0.00							
	Memo								
	Quality Control								

11/06/06

1 0 11/06/06

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ ☐ Sikaflex-291batch: 116945 ☐ ☐ ☐

exp. date: 12/01/15

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐ ☐ ☐ Aluminum Rod batch: 1117456

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

BB 11/06/08

BB 11/06/08

BB 11/06/09
BB 11/06/09
BB 11/06/13

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**Setup Start**

Stop

**Cust Item ID:**[illegible]

Customer:

Reference:

Run Start

Stop

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11/06/13

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11/06/13

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 0 11/06/15

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:00
320 OF
2:30

1X 0 M/L 11/06/15

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 BR 11-6-15

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220	HandFinishing	0.00							
	HandFinish	0.00							
Hand Finishing	Memo 1- Install inserts as per Dwg D2750								
230	HandFinishing	0.00							
	HandFinish	0.00							
Hand Finishing	Memo 1-Inspect for Foreign Objects 2-Spray inside of tube with "LPS-3" batch: _____ 3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 114516 EXP DATE: 13-01 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 114189 5-Coat all exposed fasteners with "LPS Procyon" batch: 114546.								

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240 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>AM</u>	<u>11</u>	<u>06</u>	<u>17</u> (17)
250 Packaging Packaging	Pick Kit Memo	0.00 0.00							<u>11/6/17</u> SP
260 QC Quality Control	QC4- 100% Inspect kits for completeness Memo *****ensure antiseize is on AN8C21A bolts*****	0.00 0.00							(40)

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270 Packaging Packaging	Packaging Memo Package as per PPP D350-636-011	0.00 0.00				11/6/20	SD		
280 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						11/6/21	ME 11-06-21

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 69874

Parent Item: D350-636-011

Parent Item Name: Skidtube LH




Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verf: EC
 IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec
 IPP Rev: O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf: EC IPP Rev: P 10.06.22 revise
 seq110 DD verf: EC IPP Rev: Q 10.10.01 as per IIN revH
 DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2594-3  O-Ring, 205 Skidtube	?	Manufactured	No	N A		230	Each	1,020.000	8	8			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP-A		1020							
				65518		70							
				66952		950							
D3492-1  Plug		Manufactured	No	69819		230	Each	0.0000	8	8			
D3492-3  Plug		Manufactured	No	69822		230	Each	0.0000	8	8			

INV 11-06-21

BR 11-6-16

BR 11-6-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 69874

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

266.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP 80
117460 80
FP-A 186
110915 139
115589 47

8 BK 11-6-16

AN960JD816

Purchased

No

250

Each

43.0000

2

2



1/2" washer, Alum

Location

Loc Qty

Loc Code

FP-A 43
106043 43

2

D2744

Manufactured

No

110

Each

26.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG002 26
62715 2
65086 24

1

D2600-3-BENT

Manufactured

No

110

Each

14.0000

1

1



Extrusion Bent

Location

Loc Qty

Loc Code

LG 70142 14
66875 8
68137 6

1

B 11/06/02

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 3

Work Order ID: 69874

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160 Each

162.0000 8 8



Crossbolt Spacer



BB 11/06/08

Location

Loc Qty

Loc Code

LG	63	
68948	63	
LG001	99	
67766	35	
68251	64	

D2739

Manufactured No

160 Each

4.0000 1 1



350 I Beam



BB 11/06/08

Location

Loc Qty

Loc Code

LG	4	
67785	1	
68285	3	

D3490-3

Manufactured No

160 Each

86.0000 4 4



Cross Bolt Spacer



BB 11/06/08

Location

Loc Qty

Loc Code

LG	86	
68106	22	
68952	64	

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 4

Work Order ID: 69874

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No

160 Each

49.0000 4 4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

47

67773

5

68105

42

LG001

2

62450

2

ALS4-1032-225 Purchased No

220 Each

1,617.000 38 38



Insert

Location

Loc Qty

Loc Code

ST282

1617

110768

817

117717 ✓

800

D3793-3 Manufactured No

230 Each

30.0000 1 1



Wearshoe

Location

Loc Qty

Loc Code

FP018

21

68356 ✓

13

69283

8

FP019

9

64447

9

BE 11/06/09
269823 x4

38. BR 11-6-16.

1 BR 11-6-16.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 5

Work Order ID: 69874

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

69.0000

1

1



BOLT



Location

Loc Qty

Loc Code

FP

40

117511

40

FP-A

29

115960

6

116874 ✓

23

D3793-1

Manufactured

No

230

Each

31.0000

1

1



Wearshoe



Location

Loc Qty

Loc Code

FP018

31

64445 ✓

14

69285 ✓

17

D3488-041

Manufactured

No

230

Each

21.0000

1

1



Blade Fitting Assembly, LH



Location

Loc Qty

Loc Code

FP007

1

61689

1

FP008

20

62002

2

67788 /

6

68108 /

12

1 PR 11-6-16.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 6

Work Order ID: 69874

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230 Each

34.0000

1

1



Gasket



Location

Loc Qty

Loc Code

FP010

26

68357 ✓

26

FP018

8

39422

1

61712

7

1 BL 11-6-16.

AN6C44A

Purchased No

230 Each

113.0000

4

4



BOLT

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

111

117407 ✓

80

117763

31

4 BL 11-6-16.

MS21083C8

Purchased No

230 Each

113.0000

1

1



NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

112

115884

0

117291

37

117423 ✓

50

117677

25

1 BL 11-6-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 7

Work Order ID: 69874

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3536-25	Manufactured	No	230	Each	34.0000	1	1
							

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------



FP012	34	
65903	8	
68351	26	

D3631-1	Manufactured	No	230	Each	500.0000	8	8
							

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------



ST072	500	
68062	500	

D3791-1	Manufactured	No	230	Each	19.0000	1	1
							

Wearplate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP017	19	
62239	7	
68352	12	

AN960C10L	NAS1149C0332 R	Purchased	No	230	Each	0.0000	38	38
								

washer

D2745	Manufactured	No	230	Each	206.0000	8	8
							

Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP-A	206	
67764	5	
68248	201	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 69874

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,586.000

34

34



Bolt



Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1579

115422

49

116419

334

116549

96

117343

500

117508 ✓

300

117764

300

34 BR 11-6-16.

D3537-1

Manufactured

No

230

Each

34.0000

3

3



Wearpad



Location

Loc Qty

Loc Code

FP017

34

63313

2

66804

28

66935

4

3 BR 11-6-16.

AN960C816L

Purchased

No

230

Each

0.0000

1

1



WASHER



NAS 6490832R 14915

1 BR 11-6-16.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 9

Work Order ID: 69874

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

410.0000

4

4



BOLT



Location

Loc Qty

Loc Code

FP-A

1

111982

1

ST351

409

111982

2

116419

23

116549

50

116704

84

117514 ✓

100

117619

50

117688

100

4 BR 11-6-16.

NAS1611-013

Purchased

No

230

Each

168.0000

8

8



O-RING



Location

Loc Qty

Loc Code

FP

163

117291

123

117460

40

FP-A

5

116582

5

8 BR 11-6-16.

D3535-25

Manufactured

No

230

Each

30.0000

1

1



Wearshoe



Location

Loc Qty

Loc Code

FP018

30

62233

1

65167

3

68353 ✓

11

69284

15

1 BR 11-6-16

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 10

Work Order ID: 69874

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230 Each

32.0000

1

1



Gasket



Location

Loc Qty

Loc Code

FP010

32

39421

1

61704

5

68355 ✓

26

MS21043-6

Purchased No

230 Each

523.0000

4

4



NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

FP-A

40

112314 ✓

40

ST301

463

112314

463

D3493-1

Manufactured No

250 Each

72.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST062

72

66975

31

68253

41

BR 11-6-16.

H. BR 11-6-16.

11/6/17 SP

XZ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 69874

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

113.0000

2

NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

112

115884

0

117291

37

117423

50

117677

25

AN8C21A

Purchased

No

250

Each

101.0000

2

BOLT

Location

Loc Qty

Loc Code

ST344

25

117764

25

ST345

76

116381

26

117562

50

NAS1515H3L

Purchased

No

230

Each

276.0000

8

WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

236

113362 ✓

236

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Page 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 69874

Parent Item: D350-636-011


Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2741,

Blade, 350 Skidtube

Manufactured No

250 Each

44.0000

1

1

Location

Loc Qty

Loc Code

ST466

44

61341

6

63589

38

D3532-1

Spacer

Manufactured No

250 Each

35.0000

2

2

Location

Loc Qty

Loc Code

ST065

35

62218

13

66949

22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

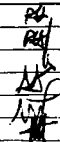
QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
1			1	D2750-4	SKIDTUBE WELDMENT, RH
		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER
NO. 69824
11-05-24

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F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
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MFG. APPR.		D2750	SHEET 1 OF
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DE APPR.		350 SKIDTUBE ASSEMBLY	NT
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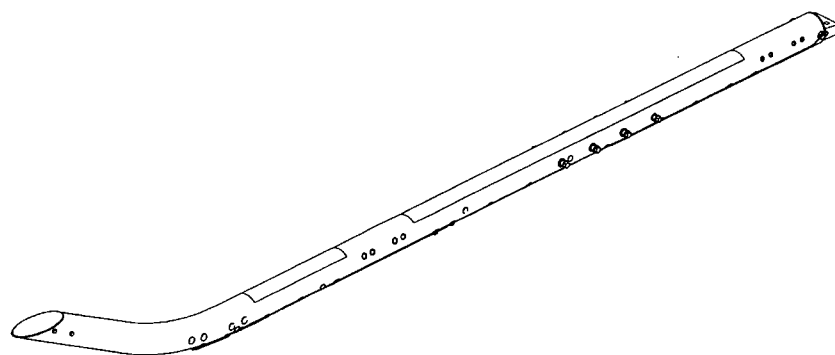
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

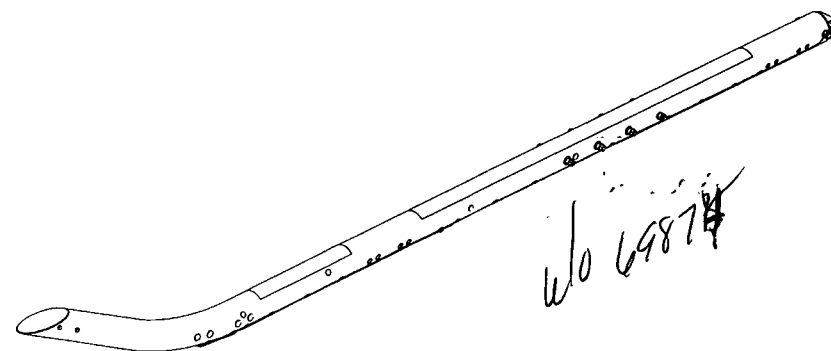
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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158 09.22.14

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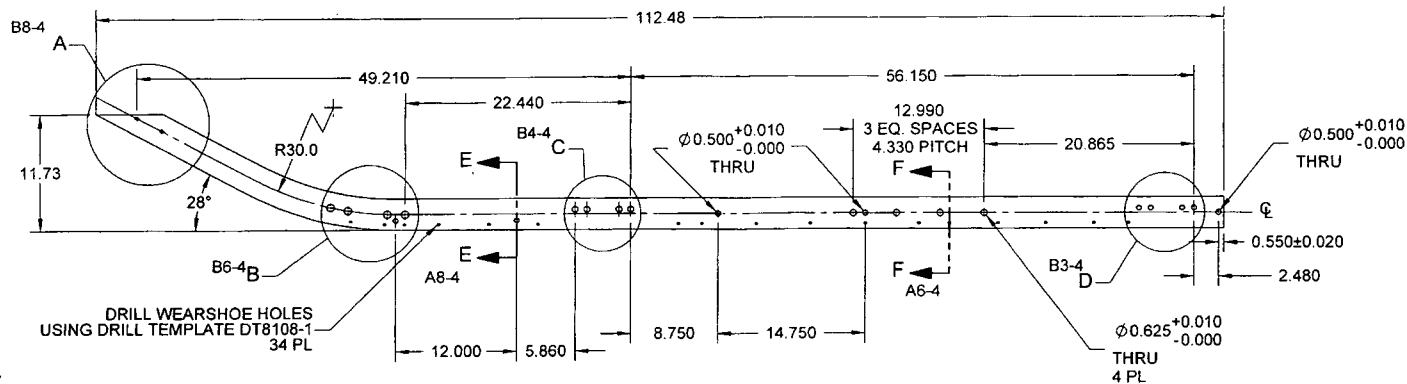
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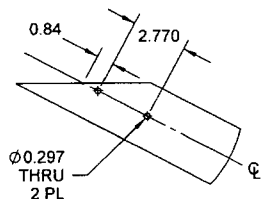
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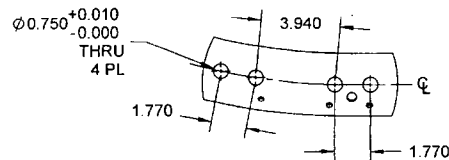


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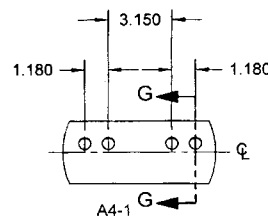
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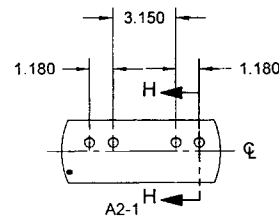
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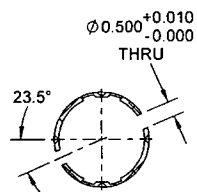
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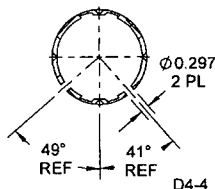
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SCALE 2X



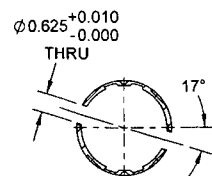
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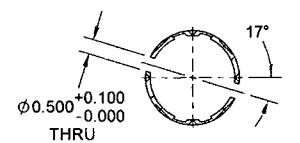
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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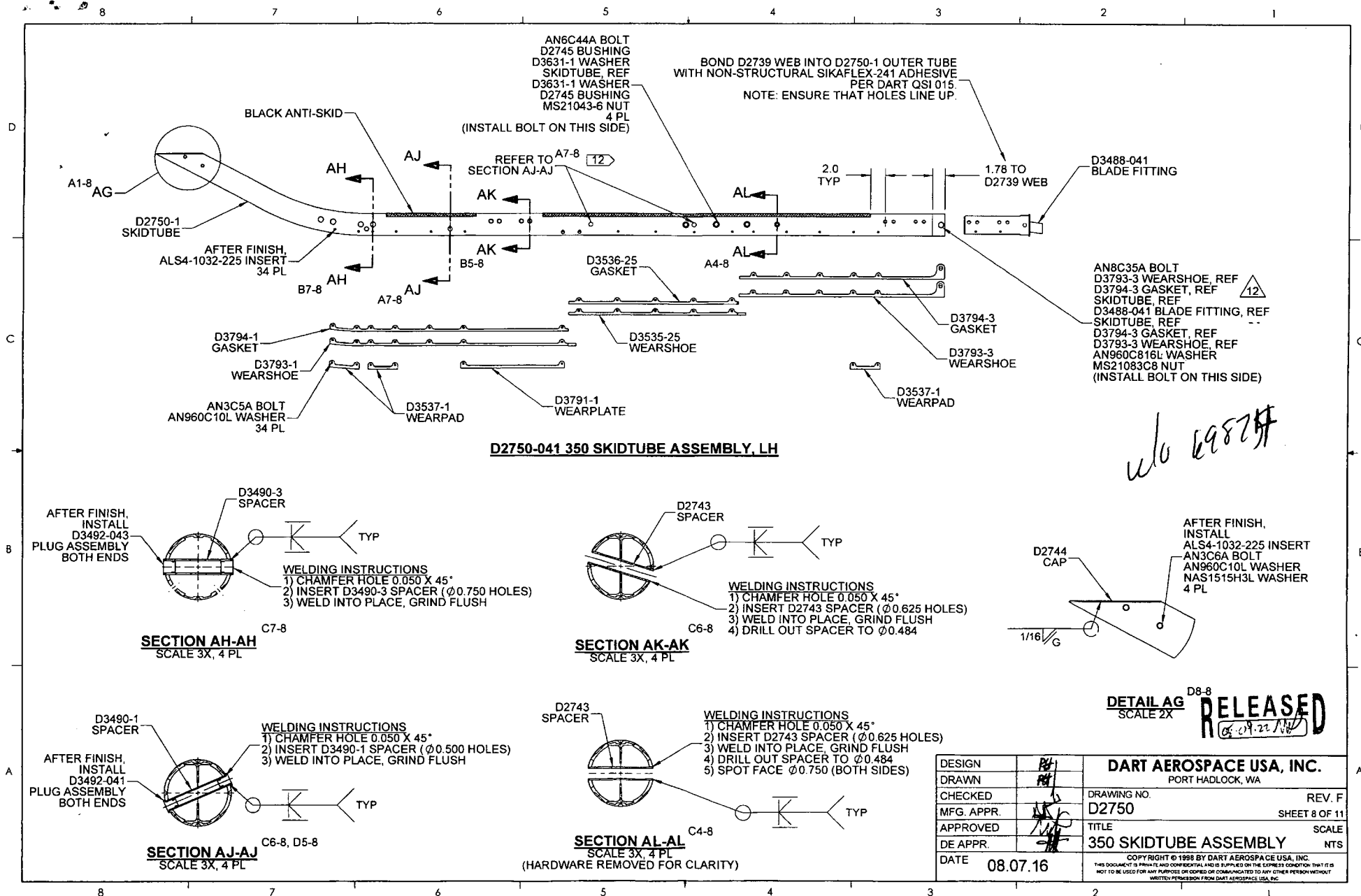
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 254

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 69872
Part number: A350 636 011
Description: 350
Welding Process: Tig ☒ Mig ☐
Base material: aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Lewis Date of Test Coupon 11.06.08
Welder Barclay Elliot Date of Test Coupon 11/06/08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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